Monday, December 06, 2010 8:17:54 AM

Page 1

Item ID:

D3635-3

Accept

Setup Start

Revision ID:

Item Name: Gasket

Required Date: 12/13/2010

12/6/2010

Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: 10/2-6

Tooling:

Date:

Run

Start

Stop

Stop

QC:

Date:

SPC (Y/N):

Date:

Qty

Sequence ID/ **Work Center ID**

Operation Description

Revision Nbr

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty

B10-13-6

Reject Number

Insp. Stamp

Draw Nbr

D3635 Rev A

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo 1-Cut as per Dwg D3635

0.00

0.00

110

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

B10-18-6

Quality Control

Memo

0.00

120

Quality Control

Memo

QC8- Inspect parts - second check

0.00

Dart Aerospace L	td
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	-								
W/O:			WC	RK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	
						i			
							;		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No Do	QA:	Date:	
	Re	esolution:	Disposition	າ:	QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)			
		Description of NC			ection B	Veri	fication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& _{Se}	ction C	Chief Eng	QC Inspector
					,	1			

Work Order ID 64417

Monday, December 06, 2010 8:17:54 AM



Page 2

Item ID:

D3635-3

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Gasket

Required Date: 12/13/2010

12/6/2010

Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location. \(\frac{1}{2} \)

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Stamp Number

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10/12/07 H

W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date (Approva Chief Eng /	Approval QC Inspector
							Prod Mgr	
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: Yes I	No DQA:	Date:	
		esolution:						
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR			
	0755	Description of NC			ion B	Verificat	tion Approva	I Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		QC Inspector
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<u> </u>		A 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1						

Picklist Print

Monday, December 06, 2010 8:17:59 AM

Work Order ID: 64417

Parent Item: D3635-3

Parent Item Name: Gask a



Start Late: 12/6/2010

Required C. te: 12/13/2010

Start Qty: 10.00

Required Qty: 10.00

_				
C_{i}	٦m	me	nte	•

IPP Rev:A New Issue 07-07-24 ec

Verified By:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063	10 110111 20110 B1102 1111 1821	Purchased	No			110	sf	368.4220	0.021	0.233333	٥.		
										B		6	

NEOPRENE SHEET 0.063

- Location	Loc Qty	Loc Code
MAT	368.422	
115500	75.622	
115916	292.8	

Page 1

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	·
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
D.4.T.F.	0750	Description of NC			tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
	;								

DART AEROSPACE LTD	Work Order:	44411
Description: Gasket	Part Number:	D3635-3
Inspection Dwg: D3635 Rev: A		Page 1 of 1

	FIRST	ARTICLE IN	ISPECTIO	ON CHE	CKLIST		
	X	First Artic	cle	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Ø0.26	+0.006/-0.001	. No	1		VBUZ		
Ø0.19	+0.005/-0.001	190	8		V		
2.94	+/-0.030	2.949	4		U		
2.14	+/-0.030	2,141	X		V		
0.3 🤄	+/-0.030	.380	ge		V		
0.40	+/-0.030	40	9		V		
0.75	+/-0.030	762	4		V		
0.80	+/-0.030	,199	x		J		
0.063	+/-0.010	,004	¥		V		
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Measured by: 🗜		Audited by:	8		Prototype Ap	proval:	N/A
Date: ιΟ	7-17-6	Date:	10/12/0	6		Date:	N/A

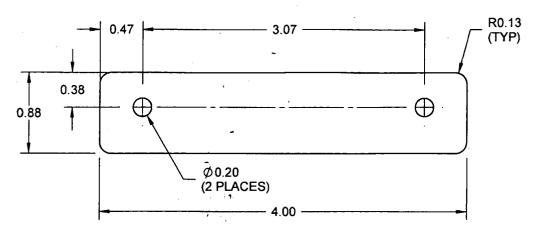
	Date:	10-17-6	Date: 10 12 06	Date:	N/A
Rev	Date	Change		Revised by	Approved
Α	07.09.06	New Issue	· · · · · · · · · · · · · · · · · · ·	KJ/JLM A	B

										
W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Categ	jory:	NCR: Y	es No	DQA:	Date: _		
	Re	solution:	Disposition: (QA: N/C	Closed:		Date:		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP Description of NC Section A		Corrective Action Secondarial Action Description		etion B	jn&∣ j	erification Section C	Approval Chief Eng	Approval QC Inspector	
- 1 -10		Coolin	Chief Eng	Chief Eng	D	ate				
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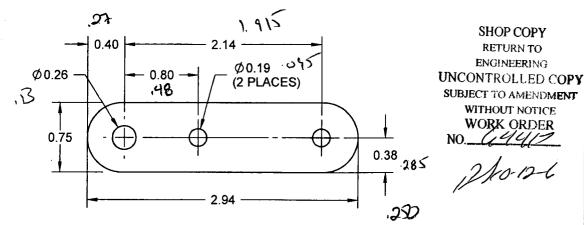
DESIGN		N AS	DRAWN BY	# - • · · · · · · · · · · · ·	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHECKED PH		APPROVED	DRAWING NO. D3635	REV. A SHEET 1 OF 1			
	07.06.01			GASKET	SCALE 1:1			
	REV DATE			DESCRIF	TION			
i	Α		07.06.0	1 NEW ISSUE				

RELEASED 07.07.11



D3635-1 GASKET

1) MATERIAL: BLACK 60 DUROMETER NEOPRENE SHEET (0.125 THICK, REF) (REF. DART SPEC. M-NEO60-S.125)



WITHOUT NOTICE WORK ORDER

SHOP COPY

RETURN TO ENGINEERING

28012-6

D3635-3 GASKET

2) MATERIAL: BLACK 60 DUROMETER NEOPRENE SHEET (0.063 THICK, REF) (REF. DART SPEC. M-NEO60-S.063)

D3635-1/-3 GENERAL NOTES:

3) FINISH: NONE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
 									
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		•	WORK ORDI	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verifica		Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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